

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020417**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Gang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

: On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 13AE

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007G-088,092.Located on SEG3007G. The welder is identified as 055491. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as SEG3007J-073.Located on SEG3007J. The welder is identified as 067079. ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

WELDING INSPECTION REPORT

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SHIELDED METAL ARC WELDING (SMAW).

This QA Inspector observed the welding operation per the (SMAW) process in the (2G) Vertical position on a weld joint identified as WR19132, . The welder is identified as 058087. The ZPMC Quality Control (QC) is identified as Mr. Gang Wei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G-(2F)-FCM-REPAIR.

MAGNETIC PARTICLE TESTING (MT)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG segment LD3040 and LD3041. The welds designations reviewed are as follows: LD3041 AND LD3040 BMR (IR 1656). This MT was performed on areas where temporary attachments were removed

IN PROCESS VISUAL INSPECTION

This QA Inspector Mr. Manuel Teall performed a preliminary random visual inspection on OBG Segment 13AE and found that an area of base metal previously gouged by ZPMC had a linear indication measuring approximately 10mm in length. The linear indication is at the toe of weld number SEG3007G-124.

On this date Caltrans OSM Quality Assurance (QA) Inspector, Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 13AE

The CWI Geng Wie was notified of the crack on weld SEG3007G-124 which is listed above. I informed the QC and the CWI that they needed to be a CWR issued before they repair the area listed above.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Teall, Manuel	Quality Assurance Inspector
Reviewed By:	McClendon, Timothy	QA Reviewer
